

Date: Tuesday, 19/08/2008 4:04:11 PM
 User: Julie Lecocq

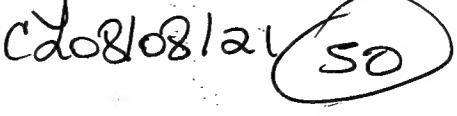
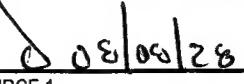
Process Sheet

| | | | | | | | |
|-----------------------|---|--|--|------------------|-------------------------------|--|--|
| Customer | : CU-DAR001 Dart Helicopters Services | | | Drawing Name | : AFT CAP | | |
| Job Number | : 41435 | | | Part Number | : D2646 | | |
| Estimate Number | : 10312 | | | Drawing Number | : D2646 REV C | | |
| P.O. Number | : | | | Project Number | : N/A | | |
| This Issue | : 19/08/2008 S.O. No. : | | | Drawing Revision | : C | | |
| Prsht Rev. | : NC | | | Material | : | | |
| First Issue | : / / Type : PURCHASED PARTS | | | Due Date | : 20/09/2008 Qty: 50 Um: Each | | |
| Previous Run | : 37755 | | | | | | |
| Written By | : | | | | | | |
| Checked & Approved By | : JMD 08.8.19 | | | | | | |
| Comment | : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM Est Rev:H Changed Inserts 07-02-19 JLM est rev I changed inserts 07.06.11 EC | | | | | | |

Additional Product

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|--|-----------------------|--|
| 1.0 | PG | PURCHASING  |
| Comment: PURCHASING Issue P/O: <u>7000</u>   1-Spin as per Dwg D2646 2-Material release note required | | |
| 2.0 | D2646P | Aft Cap  |
| Comment: Qty: 1.0000 Each(s)/Unit Total: 50.0000 Each(s) AFT CAP | | |
| 3.0 | PACKAGING 1 | PACKAGING RESOURCE #1  |
| Comment: PACKAGING RESOURCE #1 Receive & Inspect for Transit Damage Ensure Material Release Note is attached | | |
| 4.0 | QC6 | DIMENSIONAL CHECK  |
| Comment: DIMENSIONAL CHECK Inspect dimensions as per Dwg D2646    | | |
| 5.0 | SMALL FAB 1 | SMALL & MEDIUM FAB RESOURCE 1  |
| Comment: SMALL & MEDIUM FAB RESOURCE 1 1-Drill using DT8026 as per Dwg D2646.   | | |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
| | | | | | | | | |
| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:11 PM
User: Julie Lecocq

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 41435

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

EF 08/09/02 (50)

7.0 HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

08-09-03 X50

8.0 POWDER COATING

POWDER COATING



M108523



(50X)

Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

1:45

OF

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

320

2:15

M-H 08/09/12

9.0 QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

A.M 08 09 - 13 (50)

10.0 ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total: 100.0000 Each(s)

INSERT

Batch:

M105819

M-H

(50X)

11.0 SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

M-H

08/09/13

12.0 QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

Job 0809-15 (50)

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Date: Tuesday, 19/08/2008 4:04:12 PM
User: Julie Lecocq

Process Sheet

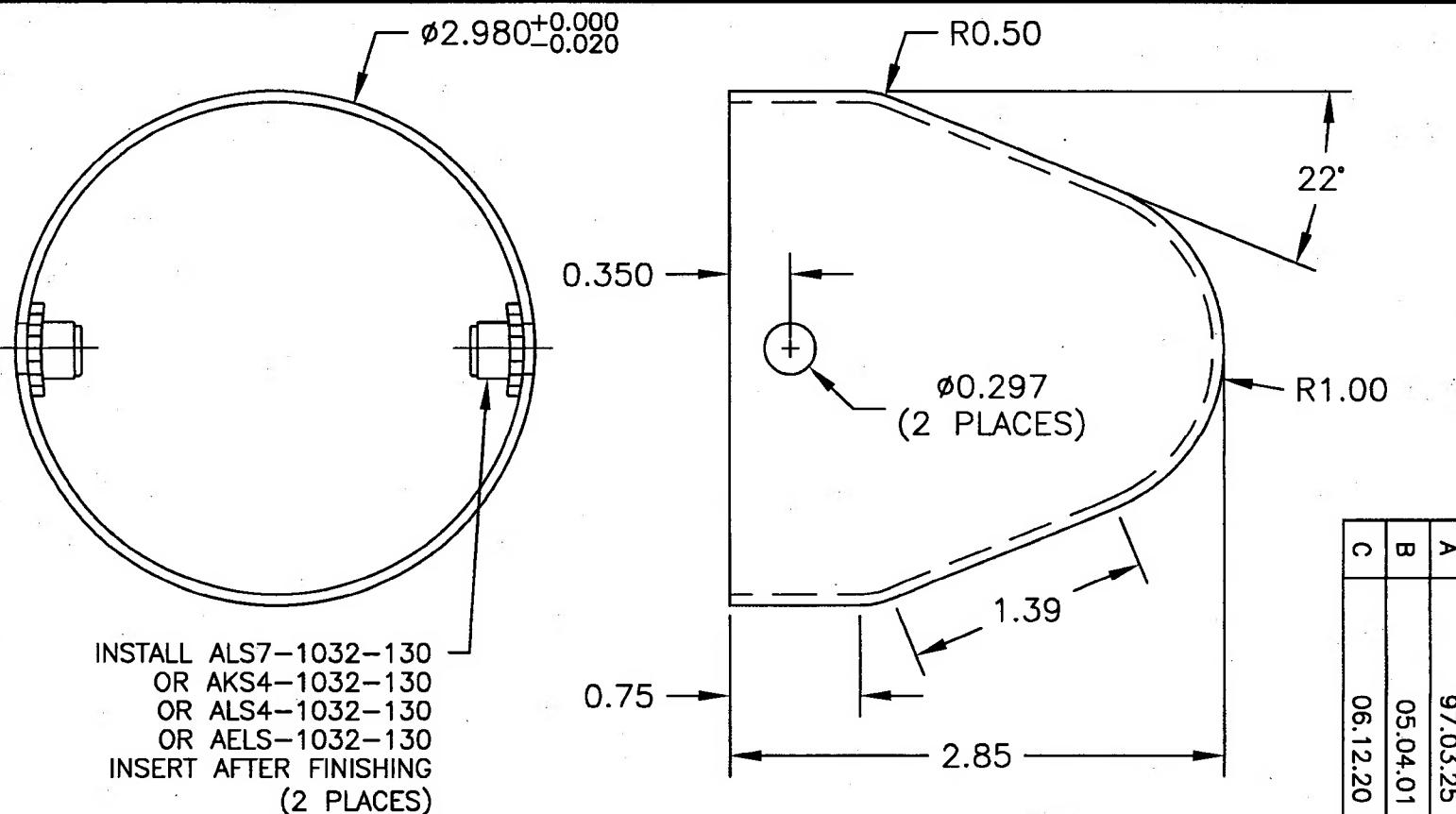
| Customer: CU-DAR001 Dart Helicopters Services | | Drawing Name: AFT CAP |
|---|--|--|
| Job Number: 41435 | | Part Number: D2646 |
| Job Number:  | | |
| Seq. #: | Machine Or Operation: | Description : |
| 13.0 | PACKAGING 1  | PACKAGING RESOURCE #1  50x |
| Comment: PACKAGING RESOURCE #1 Identify and Stock Location: <u>FP - 7</u> | | <u>m/f 08/09/15</u> |
| 14.0 | QC21  | FINAL INSPECTION/W/O RELEASE  <u>08/09/15 JJ</u> |
| Comment: FINAL INSPECTION/W/O RELEASE | | |
| Job Completion  | | <u>m/f 08-09-15</u> |

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
| | | | | | | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

DART**D2646 AFT CAP**

- 1) MATERIAL: ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) ALL DIMENSIONS ARE IN INCHES
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

RELEASED
07.02.12

| DESIGN DS | DRAWN BY | DART AEROSPACE USA, INC. | |
|-----------|----------|------------------------------|------------------|
| CHECKED | APPROVED | DRAWING NO. | PORT HADLOCK, WA |
| DATE | | TITLE | REV. C |
| | | D2646 | SHEET 1 OF 1 |
| A | 97.03.25 | NEW ISSUE | |
| B | 05.04.01 | CHANGE TO CLOSED INSERTS | |
| C | 06.12.20 | CHANGE TO OPEN ENDED INSERTS | 1:1 |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 14635



Sieg's Manufacturing Ltd.
Metal Stamping & Fabricating

6236 - 205 STREET, ALEXANDER VALLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • Fax: (604) 530-7490

Packing Slip

Packing Slip No.: 35672
Date: 08/27/2008
Page: 1

| Sold to: | Ship to: |
|--|---|
| DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 | DART AEROSPACE LTD. 1270 ABERDEEN STREET HAWKESBURY, ONTARIO K6A 1K7 |
| Order No.: 7000 | Sold By: KAULBARS, KALE |
| Shipped By: fedex | Ship Date: 08/27/2008 |
| Tracking No.: | |

| Item No. | Unit | Quantity |
|-----------------|------|----------|
| B2646P | EACH | 50 |
| <i>08/08/08</i> | | |
| Comment: | | |



Stylized Manufacturing Ltd.

Engineering and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7

TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: Aug. 27/08

Customer: Dart Aerospace

Packing Slip: 35672

| Part#: | Quantity | Material | Check holes | Debur edges | Insp. By |
|--------------|----------|-------------|-------------|-------------|----------|
| B41435 rev.C | 10 | 14G 1100 | N/A | ✓ | JK |
| | | | | | |
| | | | | | |
| | | | | | |

Notes:

Aug 28/08

Material Certification Attached: Yes.



ALCOA ALUMINUM PRODUCTS
1480 Manheim Pike
Lancaster Pa. 17601

Certification of Test Results

P/N 970200 PO 38C880

SHIPPED TO

SHIP TO

CERT NO 3000675996
DATE 4/23/2007
SKID NO 661033
SKID WGT 9,885
PAGE 1 OF 1

| | | | | | |
|----------|--------|---------|----------|--------|---|
| ORDER NO | LGS947 | PO NO | 43-62756 | | MILL FINISH NON ANODIZE QUALITY OUT: STANDARD MILL FINISH IN: STANDARD MILL FINISH NOT EMBOSSED |
| ITEM NO | 1 | PART NO | | | |
| ALLOY | 1100 | TEMPER | O | FORM | |
| GAUGE | .06300 | WIDTH | 48.5000 | LENGTH | |

LOT: 334171 COIL: B01 DROP: 07T0187

| | | | | | | | | | |
|---------|------|------|------|------|------|------|------|------|------|
| INGOT | Si | Fe | Cu | Mn | Mg | Cr | Ni | Zn | Ti |
| U718321 | 0.12 | 0.49 | 0.12 | 0.02 | 0.01 | 0.01 | 0.01 | 0.31 | 0.01 |

HEAD ULTIMATE STRENGTH 13.1 KSI

TAIL ULTIMATE STRENGTH 13.0 KSI

HEAD YIELD STRENGTH (OFFSET = .2%) 5.5 KSI

TAIL YIELD STRENGTH (OFFSET = .2%) 5.3 KSI

HEAD ELONGATION (G.L. = 2 IN) 32 %

TAIL ELONGATION (G.L. = 2 IN) 31.5 %

* AS REPORTED BY SUPPLIER

MECHANICAL PROPERTIES ACCORDING TO ASTM B-557-06

MECHANICAL AND CHEMICAL PROPERTIES MEET THE REQUIREMENTS OF:

ASME SB209 1100 C, AMS 4001H 1100 O,

ASTM B209-06 1100 O, AMS-QQ-A-250/1 1100 O

PAX CERTS: 7L4-736-4840

* END OF CERTIFICATION *

We hereby certify that, unless otherwise indicated, the material covered by this report has been manufactured, inspected, and tested in accordance with, and has been found to meet, the applicable requirements described herein, including any specifications forming a part of the description and test samples representative of the material and its composition. Also, note that mercury is not a normal contaminant in aluminum alloys and neither it nor any of its compounds are used in the manufacture of our products. Certification and test results shall not be reproduced except in full.

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Authorized By:

JEFF KREADY, LAB SUPERVISOR

TRADER SIGNATURE: *Jeff Kready* Order No. 376276
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